

Date
1/5/06

Thursday, 3/30/2006 10:06:20 AM

Kim Johnston
Kim Johnston

Process Sheet

Split

SB
06/05/06

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP SPACER
Job Number	: 26452D -1		
Estimate Number	: 10380		
P.O. Number	:	Part Number	: D30657
This Issue	: 3/30/2006 S.O. No. :	Drawing Number	: D3065 REV. A2
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/1 Type : SMALL /MED FAB	Drawing Revision	: A2
Previous Run	: 26211D	Material	: N/A
Written By	:	Due Date	: 4/15/2006
Checked & Approved By	: <u>06.03.30</u>	Qty:	60 Um: Each
Comment	: Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S040 2024-T3 .040 sheet



Comment: Qty.: 0.1653 sf(s)/Unit Total : 9.9162 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.040" thick

(M2024T3S.040)

Batch: M 19295

2.0

SHEAR

SHEAR



Comment: SHEAR

Cut blank: 4.580" x 4.500" Grain along 4.500"

W 06/04/27 (60)

3.0

HAAS

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Cut as per Machine as per Folio FA181 and Dwg D3065

Stack of 15

Identify as D3065-7

Dwg Rev: A2Prog Rev: A2
M 06/04/27 (60)

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

W 06/04/27 (60)

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

W 06-04-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 12 Date: 26/05/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
26/05/04	9	2 piece were found in the alodine basket. Alodine burn on parts.	AB 06/05/04	Scrap: destroy Retrain employee	FC 06/05/04	2 06/05/04	AB 06/05/04	2 06/05/04

NOTE: Date & initial all entries

Date: Thursday, 3/30/2006 10:06:20 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 26452D

Part Number: D30657

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr Stack

mf

H.M. 06-05-01
M.F. 06-05-01

55
57

7.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE
Bend as per Dwg D3065

SB

06/05/02

57

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-05-03

(57)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

H.M. 06-05-02

55

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

SB 06/05/02

(55)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: *GA*

SB 06/05/02

55

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

06/05/04

(55)

Job Completion



W 06-05-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

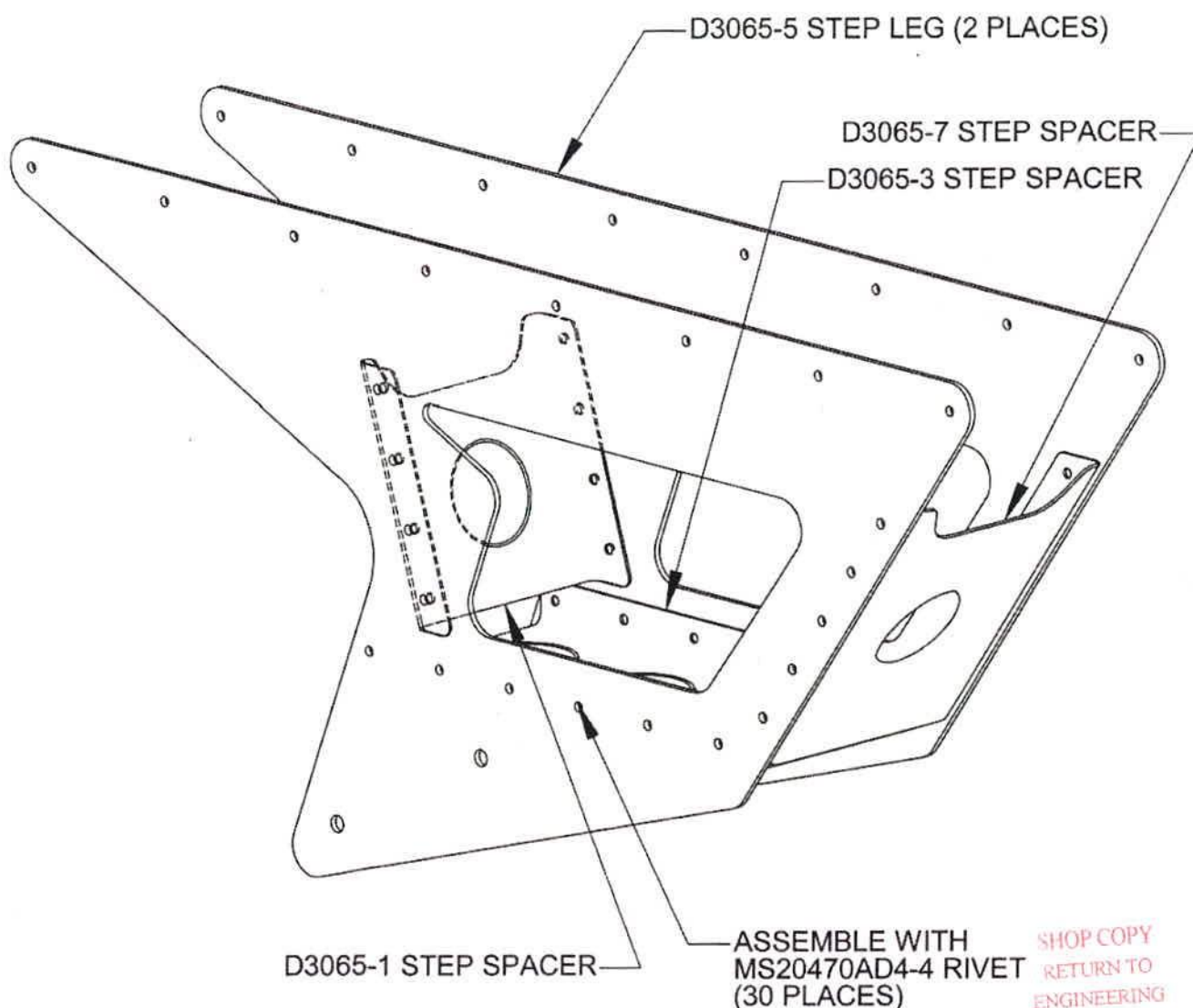
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3065	REV. A SHEET 1 OF 5
DATE 02.09.11		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
A1	03.02.13 CP	ADD SLOTS TO D3065-5	
A2	03.02.27 CP	0.551 WAS 0.410	

RELEASED
02.09.20 #



D3065-041 STEP LEG ASSEMBLY

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WORK ORDER
NO. 26452 D

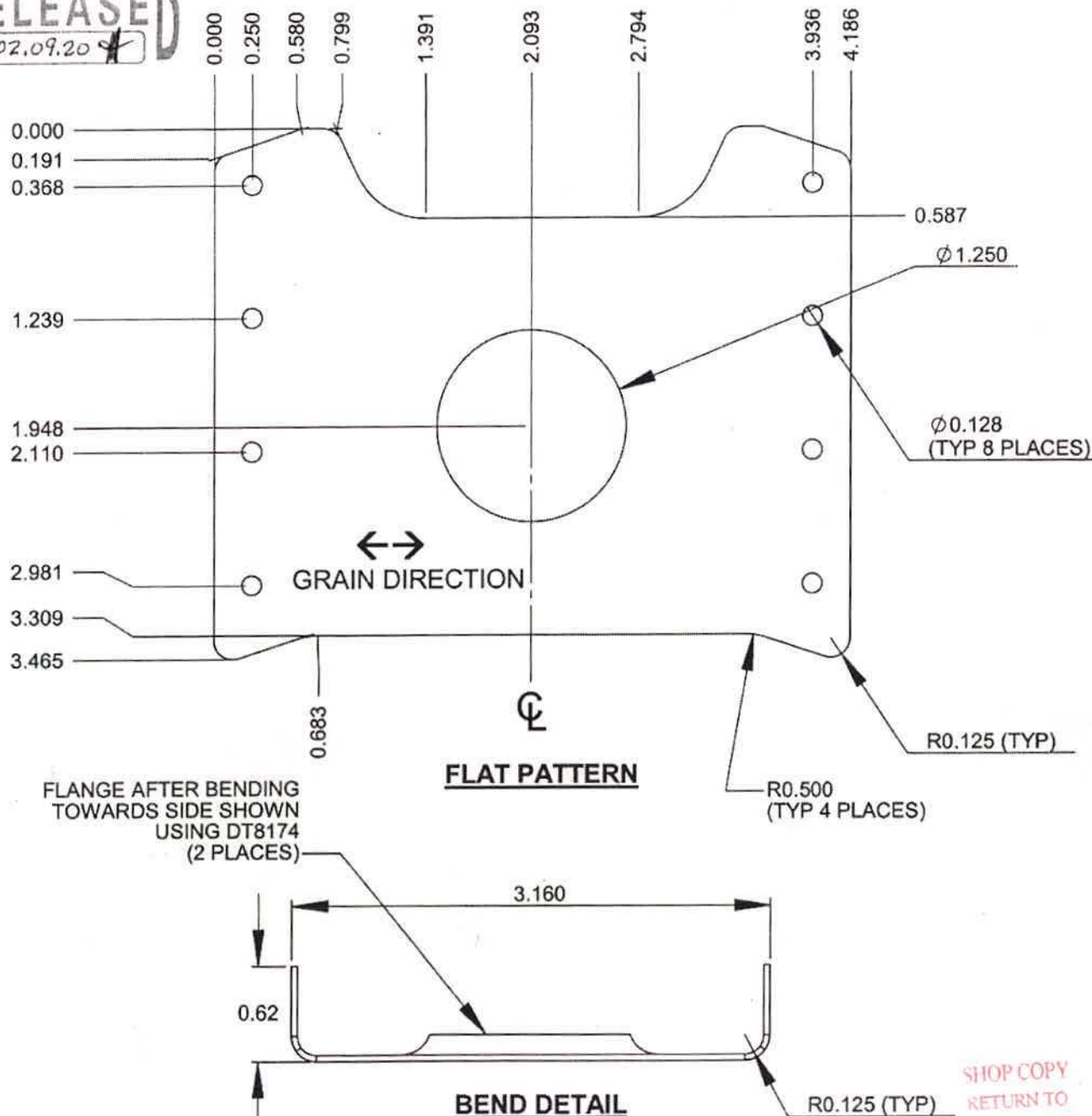
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DATE 02.09.11		TITLE STEP LEG ASSEMBLY	SCALE 1:1

RELEASED
02.09.20



D3065-1 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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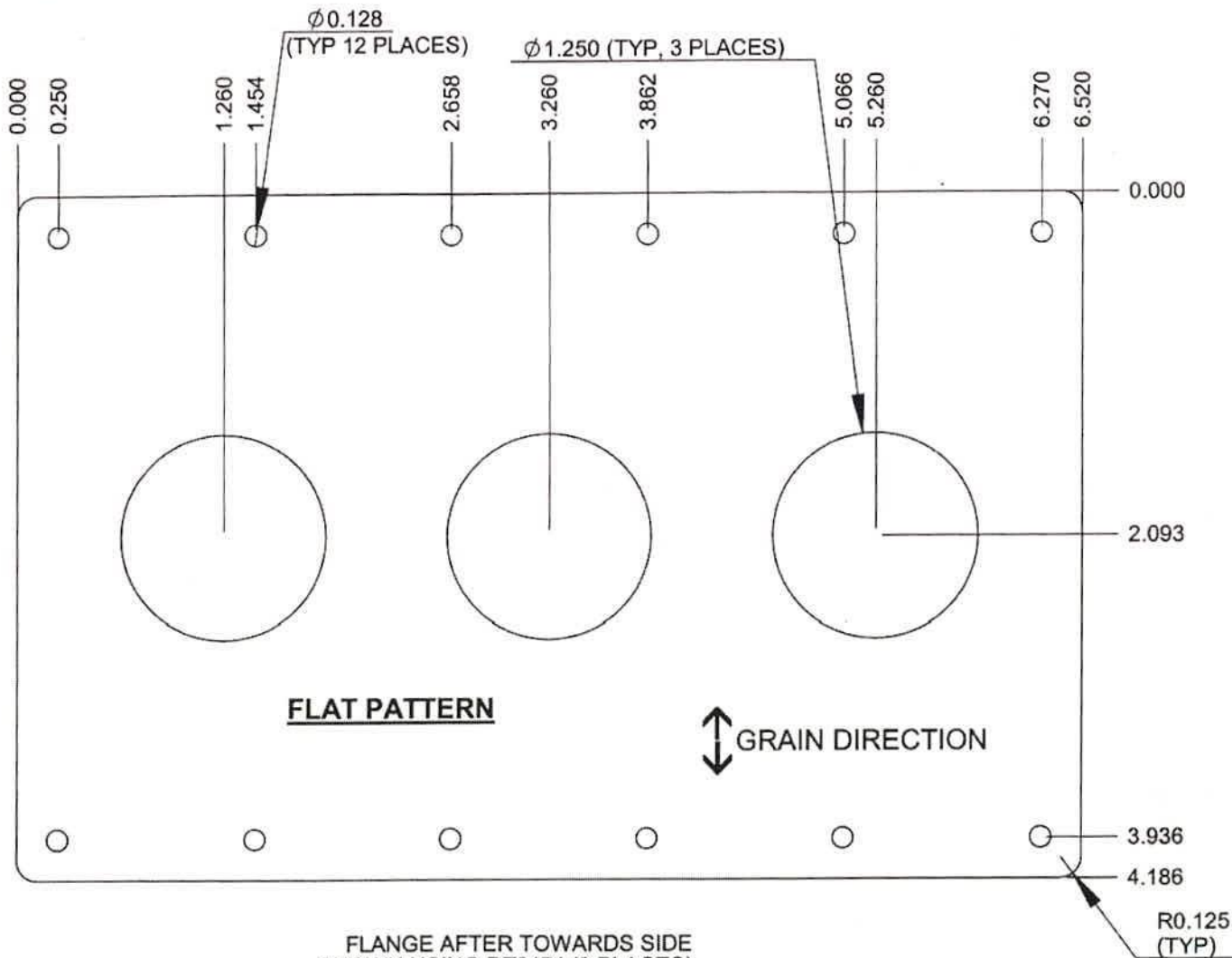
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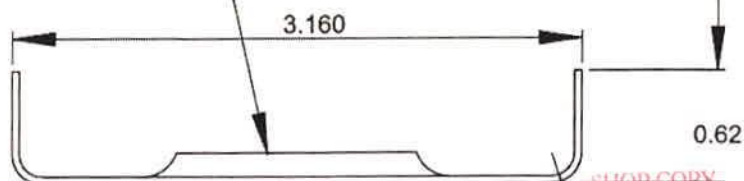
DART



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CHECKED H	APPROVED H	DRAWING NO. D3065	REV. A SHEET 3 OF 5
DATE 02.09.11		TITLE STEP LEG ASSEMBLY	SCALE 1:1



FLANGE AFTER TOWARDS SIDE
SHOWN USING DT8174 (3 PLACES)



D3065-3 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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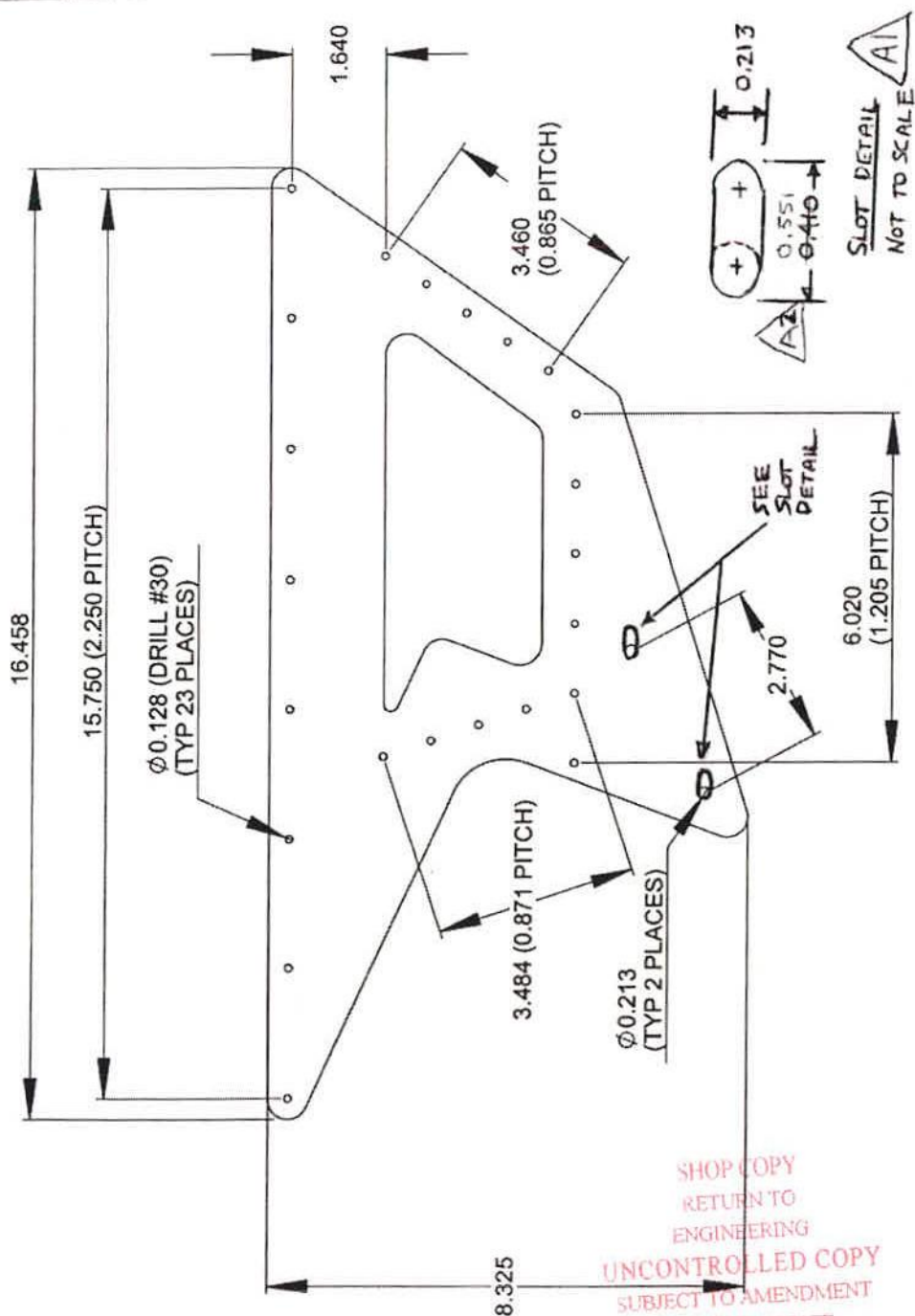
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. A SHEET 4 OF 5
DATE 02.09.11		TITLE STEP LEG ASSEMBLY	SCALE 1:3

RELEASED
02.09.20 #



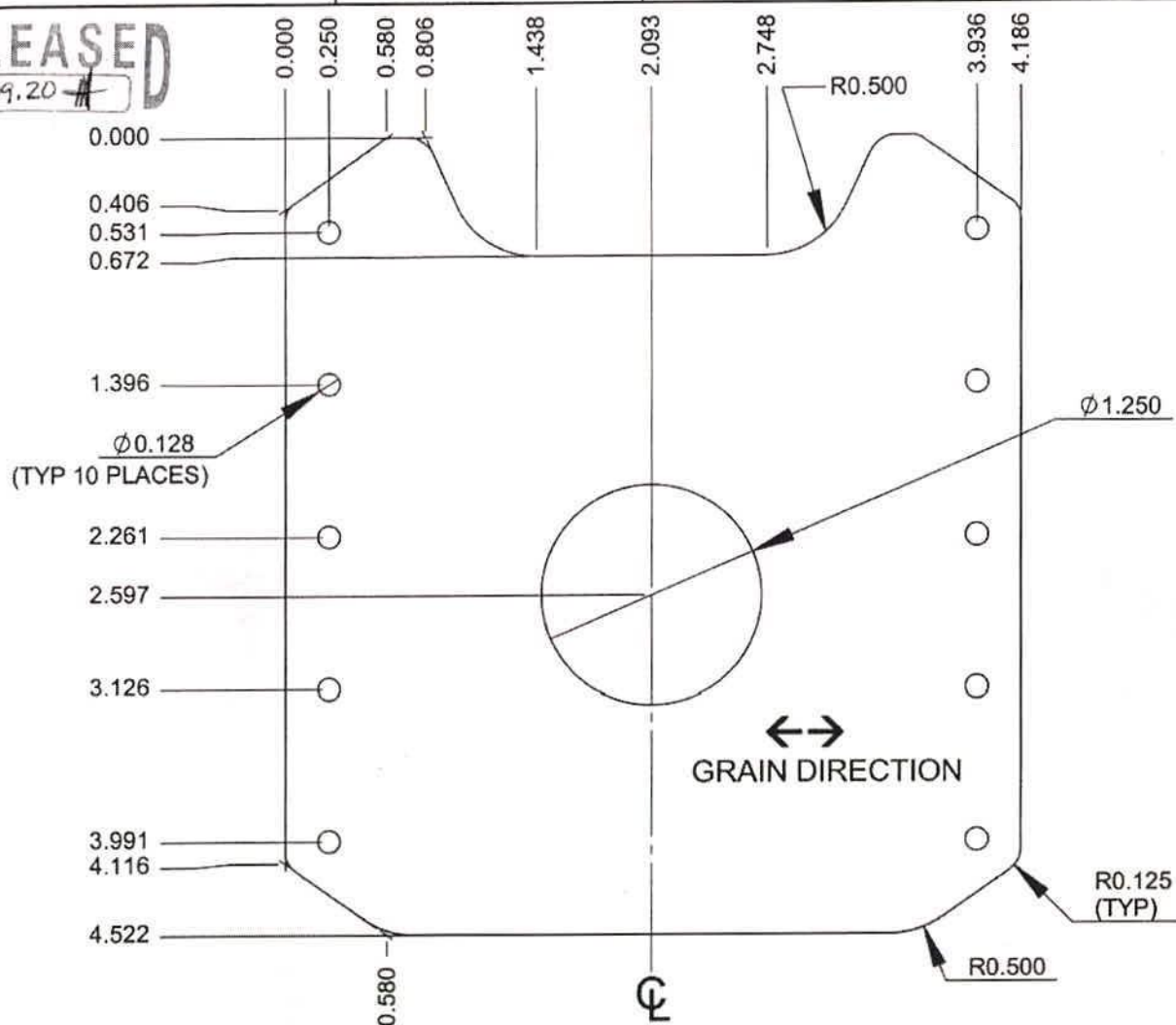
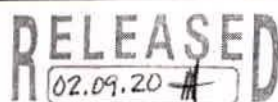
- D3065-5 STEP LEG**
- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
 - 2) MATERIAL: 5052-H32 (QQ-A-250/8) 0.080 THICK (REF DART SPEC. M5052H32S.080)
 - 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
 - 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
 - 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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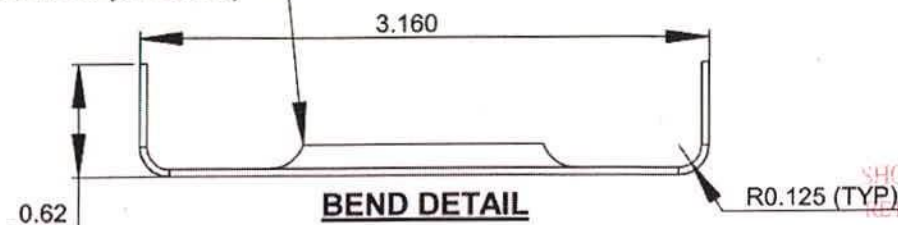
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DATE 02.09.11		TITLE STEP LEG ASSEMBLY	SCALE 1:1



FLANGE AFTER BENDING TOWARDS
SIDE SHOWN USING DT8174 (2 PLACES)



D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
3) PART IS SYMMETRIC ABOUT CENTERLINE
4) BREAK ALL SHARP EDGES 0.005 TO 0.010
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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